



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

001512

646.4001
Job Sheet 173012



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV:C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV:C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/16/18	0.00	0.00	Start Up Stores/Pkg-1		SP [Signature] MAR 20 2018
110	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging1-1		[Signature] MAR 26 2018
120	QC	1 pcs		3/16/18	0.00	0.00	QC4		[Signature]
125	DC	1 pcs		3/16/18	0.00	0.00	DC		[Signature]
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-1		[Signature]
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPP 646.4001

Descriptions: 130 - Identify and pack for shipping as per PPP 646.4001 Location: Fg102

DAS
21
9-80

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	

7159851
5026731
7159800
7159850
5026842
5026885



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CANADA
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Container No: S052913



Part: 646.4001

Job No: 173012

Serial No/Batch: S052913

Revision:

Inspector:

Date: 03/20/18

646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5038795
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5036739
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5027821
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5036884
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5019883
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5027801
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5159802
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5038813
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5126060
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5140671
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5041554
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5034597
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5035800/5043733
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5027721
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5153854
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5003045
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5015688
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5019388
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5041106
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5000530
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5019359
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5019400
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5027516
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5019413
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5019421
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5019378
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	FM133922-36
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	FM134062
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	5124089
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5123425
MS21042L08	Use Ms21042L08	2 Ea (2 ea)	90-Start up Operation	5016879
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5038764
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5045901
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5016884(12)/5020620(6)
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5016502
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	3004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5024480
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	FM138621.0
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5019320-1
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5006970
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5027544
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5027545
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5024444
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	500680
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	FM124904-10
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5020603
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5027738
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5034412
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5020604

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	496	0
	600.0990	1	24	0
	600.0991	1	24	0
	600.1012	1	34	0
	600.1013	5	70	0
	646.2910	1	5	0
	646.3001	1	12	0
	646.3110	1	12	0
	646.3210	1	4	0
	646.3301	1	9	0
	646.3510	1	24	0
	646.3511	1	13	0

646.3610	1	27	0
646.3710	1	22	0
646.3711	1	31	0
646.3712	1	44	0
646.3713	1	41	0
646.3714	1	42	0
646.3715	2	54	0
646.3716	1	29	0
646.3717	1	34	0
646.3718	2	56	0
646.3719	2	28	0
646.3810	2	27	0
646.3811	1	9	0
646.3812	2	24	0
646.3813	1	21	0
646.3910	4	45	0
646.3911	1	44	0
646.3912	4	36	0
646.3913	1	60	0
646.9410	1	29	0
647.0112	2	91	0
647.7703	2	20	0
650.9201	2	25	0
AN3-11A	10	390	0
AN3-12A	2	48	0
AN3-13A	1	63	0
AN3-3A	4	265	0
AN3-4A	10	310	0
AN3-5A	2	484	0
AN3-6A	2	187	0
AN316C4R	2	42	0
AN44-5A	2	39	0
AN4C7A	2	127	0
AN665-34R	2	70	0
CCR264SS3-02	36	794	0
CR3213-5-3	14	222	0
MS20426AD5-7	2	1,241	0
MS20470AD5-5.5	8	445	0
MS20470AD5-6	8	319	0
MS20470AD5-7	3	224	0
MS21042-08	2	0	0
MS21042L3	63	3,421	0
MS21042L4	2	1,006	0
MS21047-3	18	602	0
MS24693-C278	5	100	0
MS24694-S51	5	319	0
MS24694-S54	2	149	0
MS24694-S55	3	76	0
MS27039-08-13	2	451	0
MS27039-1-10	2	401	0
MS27039-1-12	6	217	0
MS27039-1-16	24	304	0
MS27039-1-19	22	257	0
MS27039-1-20	2	87	0
MS27039-1-21	4	135	0
NAS1149F0332P	144	3,515	0
NAS1149F0363P	2	269	0
NAS1149F0432P	4	1,196	0
NAS1149FN832P	4	4,243	0

Part Specifications

Specifications could not be found.



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Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001512	S049778	600.0129	VHB Tape	fm137700	CCK096	8
001512	S049781	600.0990	Magnabond 6398 Part A Size 112 ml	s039651	LG050	1
001512	S049783	600.0991	Magnabond 6398 Part B Size 112 ml	s039652	LG050	1
001512	S049785	600.1012	Sealant PR1425B2 (#654 sem)	s022034	CCK017	1
001512	S049786	600.1013	021200-3M Tape Primer 94 Primer 24216	s020598	CCK096	5
001512	S035668	646.2910	Deflector	S011143	CCK050	1
001512	S049776	646.3001	Lower Cable Cutter Assembly	s038952	CCK023	1
001512	S049775	646.3110	Channel	s044090	CCK020	1
001512	S027109	646.3210	Support		CCK020	1
001512	S030952	646.3301	Upper Cutter Assembly	S030932	CCK018	1
001512	S049779	646.3510	Strut	s036174	CCK104	1
001512	S049780	646.3511	Strut	s036176	CCK104	1
001512	S021893	646.3610	Filler	S021508	CCK104	1
001512	S049774	646.3710	Doubler	s002104	CCK006	1
001512	S049797	646.3711	Clip	s026777	CCK104	1
001512	S049795	646.3712	Clip	f159863	CCK104	1
001512	S049773	646.3713	Gusset	f159851	CCK106	1
001512	S049771	646.3714	Gusset	s026731	CCK105	1
001512	S049770	646.3715	Strut Doubler	f159860	CCK105	2
001512	S049768	646.3716	Gauge Bracket	f159850	CCK105	1
001512	S049767	646.3717	Doubler	s026842	CCK105	1
001512	S049765	646.3718	Custom Washer	s026885	CCK105	2
001512	S049660	646.3719	Doubler	s038795	CCK105	2
001512	S049659	646.3810	Bracket	s036739	CCK105	2
001512	S049657	646.3811	Radius Block	s027821	CCK105	1
001512	S049656	646.3812	Gusset Bracket	s036884	CCK106	2
001512	S049655	646.3813	AS350 Strut Bracket	s019883	CCK106	1
001512	S049621	646.3910	Shim	s038811	CCK106	4
001512	S049629	646.3911	Shim	s027797	CCK106	1
001512	S049633	646.3912	Shim	s038813	CCK106	4
001512	S049658	646.3913	Shim	f126060	CCK106	1
001512	S049661	646.9410	Shim	f140671	CCK011	1
001512	S049600	647.0112	Strut Bracket	s041557	CCK106	2
001512	S049598	647.7703	Strut Assembly	s034597	CCK114	2
001512	S035800	650.9201	Eyelet Bracket Assembly	S049527	CCK127	1
001512	S014740	AN3-11A	Bolt		ST349	7
001512	S049564	AN3-11A	Bolt	S027721	ST349	3
001512	S049558	AN3-12A	Bolt	F153854	ST349	2
001512	S049557	AN3-13A	Bolt	S003045	ST349	1
001512	S049553	AN3-3A	Bolt	S015688	ST350	4
001512	S049410	AN3-4A	Bolt	S019388	ST350	10
001512	S049406	AN3-5A	Bolt	S041106	ST350	2
001512	S049344	CCR264SS3-02	Cherry Rivet	S019421	ST321	36
001512	S049336	CR3213-5-3	Cherry Rivet	S019378	ST319	14
001512	S049328	MS20426AD5-7	Rivet	FM133922-36	ST311	2
001512	S049324	MS20470AD5-5.5	Rivet	FM134063	ST309	8
001512	S049316	MS20470AD5-6	Rivet	F124089	ST309	8
001512	S049321	MS20470AD5-7	Rivet	F123425	ST309	3
001512	S049274	MS21042L3	Nut	S038764	ST303	63

exp.
07/20

exp.
11/2018

S0437
x1

~~S049577~~ AN316C4R

AN3-6A S000530 2X

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001512	S049276	MS21042L4	Nut	s045901	ST303	2
001512	S016884	MS21047-3	Nut Plate		ST301	12
001512	S049265	MS21047-3	Nut Plate	S020620	ST301	6
001512	S049218	MS24693-C278	Screw	S016502	ST287	5
001512	S049207	MS24694-S51	Screw	S004859	ST284	5
001512	S049201	MS24694-S54	Screw	S024480	ST284	2
001512	S049174	MS24694-S55	Screw	FM138621.0	ST283	3
001512	S049172	MS27039-08-13	Screw	S019320-1	ST278	2
001512	S049173	MS27039-1-10	Screw	s006970	ST280	2
001512	S049169	MS27039-1-12	Screw	S027544	ST280	6
001512	S049166	MS27039-1-16	Screw	S027545	ST280	24
001512	S049124	MS27039-1-19	Screw	S024444	ST280	22
001512	S049132	MS27039-1-20	Screw	S000680	ST280	2
001512	S049118	MS27039-1-21	Screw	FM127904-10	ST280	4
001512	S049046	NAS1149F0332P	Washer	S020603	ST262	144
001512	S049043	NAS1149F0363P	Washer	S027738	ST262	2
001512	S049042	NAS1149F0432P	Washer	S034412	ST362	4
001512	S049041	NAS1149FN832P	Washer	S020604	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 3/9/18 2:10 PM dart.quirion.sonia

AN44-5A S019400 2x

AN4C7A S027516 2x

AN665-34R S019413 2x

MS21042L08 ~~F124089~~ S016879 2x

REF. ONLY

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2. INSTALL F/N 14 WITH F/N 52 & 53.

3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMaster-CARR P/N 75935A651.

4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5. REUSE FASTENERS FROM F/N 1.

6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	PR-100 CLASS B				
1	1	1	77	646.9410	SHIM	Δ				
		4	76	601.2764	WASHER	NAS1149H830P				
		2	75	601.2973	LOCKNUT	MS27042-08				
		2	74	601.2988	SCREW	MS27039-0813				
		2	73	601.2943	LOCKNUT	MS27042-3				
		2	72	601.3128	NUT	AN316CAR				
		2	71	601.3209	LOCKNUT	MS27042-4				
		4	70	601.2638	WASHER	NAS1149D430P				
		2	69	601.2669	BOLT	ANAC7A				
		2	68	601.3119	CLEVIS	AN665-34R				
		2	67	601.3121	EYE BOLT	AN665-SA				
		2	66	650.9201	EYE BRACKET ASSY					
	REF	REF	65	647.5701	GPS MOUNT KIT	Δ				
			2	64	601.3151	WASHER	NAS1149D330P			
			63	601.2911	SCREW	MS27469H550				
		24	62	601.2637	SCREW	MS27039-1-16				
	2	2	61	601.2763	BOLT	AN3-12A				
		1	60	646.3913	SHIM					
		4	59	646.3912	SHIM					
		1	58	646.3911	SHIM					
		4	57	646.3910	SHIM					
		5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
		1	1	54	600.1012	SEALANT	PR-100 CLASS B			
			1	53	600.0991	MAGNIBOND 6398 PART B	Δ			
			1	52	600.0990	MAGNIBOND 6398 PART A	Δ			
	6	10	10	51	601.2826	BOLT	AN3-11A			
			2	50	646.3814	WIPER BRACKET				
			2	49	601.2910	SCREW	MS27039-1-16			
		2		2	48	601.1365	SCREW	MS27039-1-10		
		2		2	47	646.3719	DOUBLER			
			2	2	46	646.3718	CUSTOM WASHER			
			1	1	45	646.3717	DOUBLER			
		22	2	22	44	601.1948	SCREW	MS27039-1-19		
			2	2	43	601.1952	SCREW	MS27039-1-20		
			4	4	42	601.1956	SCREW	MS27039-1-21		
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 0279, 0281, 0279 & 0275	02/08/2016	P. BRAYD
B	INCORPORATED ECN 0304, 0309 & 0475	11/04/2014	P. BRAYD
C	INCORPORATED ECN 0309	09/09/2014	P. BRAYD

				2	2	41	601.2829	SCREW	MS2449454	
				2	2	40	601.2831	RIVET	MS20406AD5-7	
				1	1	39	646.3716	GAUGE BRACKET		
				6	6	38	601.1953	SCREW	MS27039-1-12	
			2		2	37	646.3715	STRUT DOUBLER		
			2	2	2	36	601.2824	BOLT	AN3-5A	
12		36			36	35	601.2277	RIVET	CC09446-9-02	
6		18			18	34	600.0795	NUTPLATE	MS27047-3	
3		3			3	33	601.2565	RIVET	MS20470AD5-7	
1		1			1	32	646.3813	STRUT BRACKET		
4		4			4	31	601.2822	BOLT	AN3-3A	
2		2			2	30	646.3812	GUSSET BRACKET		
8		8			8	29	601.2564	RIVET	MS20470AD5-6	
1		1			1	28	646.3714	GUSSET		
		1		1	1	27	646.3610	FILLER		
		3		3	3	26	601.2830	SCREW	MS2449455	
		2		2	2	25	601.2825	BOLT	AN3-6A	
		1		1	1	24	646.3811	RADIUS BLOCK		
		1		1	1	23	646.3712	CLIP		
		1		1	1	22	646.3711	CLIP		
8		8			8	21	601.2832	RIVET	MS20470AD5-8	
14		14			14	20	601.2020	RIVET	CR3213-3-3	
4		6		6	10	19	601.2823	BOLT	AN3-4A	
		1		1	1	18	601.2827	BOLT	AN3-13A	
		5		5	5	17	601.2912	SCREW	MS2449451	
1		1			1	16	646.3713	GUSSET		
1		1			1	15	646.3210	SUPPORT		
					1	14	646.3710	DOUBLER		
		1		1	1	13	646.3110	CHANNEL		
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042-3	
16	32	18	120	16	144	11	601.1607	WASHER	NAS1149D30P	
						10	646.3410	LH WIPER DEFLECTOR		
						9	646.3411	RH WIPER DEFLECTOR		
				2	2	8	647.7703	STRUT ASSY		
				2	2	7	647.0112	STRUT BRACKET		
		1		1	1	6	646.3511	STRUT		
		1		1	1	5	646.3510	STRUT		
2		2			2	4	646.3810	BRACKET		
				1	1	3	646.2910	DEFLECTOR		
		1		1	1	2	646.3001	LOWER CUTTER ASSY		
				1	1	1	646.3301	UPPER CUTTER ASSY		
X							646.4006	LOWER CUTTER FIXED PROVISIONS		
	X						646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X					646.4004	FIXED PROVISIONS KIT		
			X				646.4003	CABLE CUTTERS KIT WITH FOUR FIXED PROVISIONS		
				X			646.4002	ASS350 WIPER DEFLECTOR KIT		
					X		646.4001	ASS350 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		NEXT ASSY (S)		ORIGINAL DATE 10-27-08 DESIGNED BY P. BRAYD DRAWING APPROVAL P. BRAYD REVISION CONTRACT NO.		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300 APICAL INDUSTRIES INC. DBA DART AEROSPACE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACE DECIMALS 1.000 2 PLACE DECIMALS 1.000 1 PLACE DECIMALS 1.000						ASS350 CABLE CUTTERS KIT SRT CAGE CODE 07A16 DWG NO. 646.4000 REV C	
SCALE NONE						SHEET 1 OF 5	